

Patent Claims

1. Wood fiberboard, in particular floor panel
5 comprising an HDF support board with a top side and an
underside, the top side having a decoration, preferably
a wood or tile decoration, characterized in that the
decoration is printed onto the top side of the support
board and is covered by at least one layer of a
10 transparent synthetic resin.

2. Wood fiberboard, according to Claim 1
characterized in that the decoration is printed on to
the underside of the support board.

15 3. Wood fiberboard, according to Claim 1 or 2,
characterized in that the decoration is covered by two
layers of a synthetic resin, the layer which is applied
directly to the decoration having corundum particles
20 for increasing the abrasion resistance.

4. Wood fiberboard, according to one or more of
Claims 1 to 3, characterized in that the top side has a
relief corresponding to the decoration.

25 5. Wood fiberboard, according to Claim 4
characterized in that the underside also has a relief
corresponding to the decoration.

30 6. Process for producing a wood fiberboard according
to Claim 1 or 2, characterized by the following steps:

35 a) a decoration, preferably a wood or tile
decoration, is printed onto one or two sides of
the board;

b) a screen roller is used to spread one or more
synthetic-resin layers, preferably melamine-resin
or urea-resin layers, on the side with the

decoration (top side) and the sides located opposite the latter (underside);

- 5 c) the synthetic-resin layers are pressed with the board in a known manner in a KT-press.

7. Process according to Claim 4, characterized in that the first synthetic-resin layer applied to the decoration is provided with corundum particles.

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8. Process according to Claim 6, characterized in that in the KT-press, a relief which corresponds to the decoration provided on the top side is stamped into the synthetic-resin layer.

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9. Process according to Claim 8, characterized in that a relief which corresponds to the decoration provided on the underside is also stamped.

20 10. Process according to Claim 6, characterized in that the decoration is printed directly onto the top side and/or the underside of the support board.

25 11. Process according to one of Claims 6 to 8 or 10, characterized in that floor panels are sawn from the wood fiberboard.